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(71) Applicant: **THE WELDING INSTITUTE**
Abington Hall
Abington
Cambridge CB1 6AL (GB)

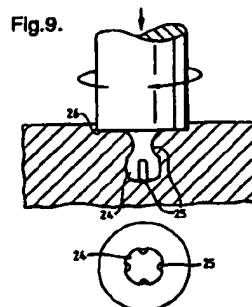
(72) Inventor: **Thomas, Wayne Morris**
6 Howe Road
Haverhill,
Suffolk CB9 9NT (GB)
Inventor: **Murch, Michael George**
6 Middle Street,
Triplow

Royston,
Herts, SG8 7RD (GB)
Inventor: **Nicholas, Edward David**
106 Abbots Road,
Haverhill
Suffolk,
Cambridge, CB9 0DH (GB)
Inventor: **Temple-Smith, Peter**
The Haven,
60 Lode Road
Lode,
Cambridge, CB5 9ET (GB)
Inventor: **Needham, James Christopher**
5 Blacklands Close
Saffron Walden,
Essex (GB)
Inventor: **Dawes, Christopher John**
9 Queensway
Sawston,
Cambs, CB2 4DJ (GB)

(74) Representative: **Skone James, Robert Edmund**
GILL JENNINGS & EVERY
Broadgate House
7 Eldon Street
London EC2M 7LH (GB)

(54) Improvements relating to friction welding.

(57) A method of operating on a workpiece comprises offering a probe (24) of material harder than the workpiece material to a continuous or substantially continuous surface of the workpiece, the probe depending from a containment member having a surface which faces the workpiece. Relative cyclic movement is caused between the probe (24) and the workpiece while urging the probe and workpiece together whereby frictional heat is generated as the probe enters the workpiece so as to create a plasticised region in the workpiece material around the probe, the containment member substantially preventing dispersal of the plasticised material. The cyclic movement is stopped and the plasticised material allowed to solidify around the probe.



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The invention relates to a method for operating on a workpiece.

Friction welding has been known for many years and typically involves causing relative movement between a pair of workpieces while they are urged together so as to generate a plasticised region, stopping the relative movement and allowing the plasticised region to solidify thereby joining the workpieces.

It has also been proposed in the past to join workpieces by making use of a "non-consumable" member which does not form part of the finished joint. An example of this approach is shown in US-A-4144110 in which the two workpieces are urged together about a rotating wheel which causes the plasticised region to be generated. The two workpieces are also translated relative to the wheel so that they are welded together along a joint region.

In accordance with the present invention, a method of operating on a workpiece comprises offering a probe of material harder than the workpiece material to a continuous or substantially continuous surface of the workpiece, the probe depending from a containment member having a surface which faces the workpiece; causing relative cyclic movement between the probe and the workpiece while urging the probe and workpiece together whereby frictional heat is generated as the probe enters the workpiece so as to create a plasticised region in the workpiece material around the probe the containment member substantially preventing dispersal of the plasticised material; stopping the relative cyclic movement; and allowing the plasticised material to solidify around the probe.

This new technique, which we refer to as "friction plunge welding" provides a very simple method of joining a probe to a workpiece. The method can be used for repairing cracks and the like within a workpiece or for joining members, such as studs or bushes, to a workpiece.

Preferably, at least part of the probe which enters the workpiece is shaped, for example tapered, so as to key into the solidified material.

The material of the workpiece can be metals, alloys or compound materials such as MMC, or suitable plastic materials such as thermo-plastics.

In some examples, the probe has an elongate axis and undergoes cyclic movement, for example a reciprocating movement, in a direction generally parallel with its elongate axis. The probe is then left in situ.

In all these methods, the probe may have a substantially circular cross-section.

In another example the probe is in the form of a slightly tapering cylinder so that it may be inserted from one side of the joint, forming a plasticised layer to the depth of penetration of the

probe.

Preferably the plasticised material is restrained from extruding from the joint region by the containment member, for example a suitable cap or shoe which closely fits the workpiece surface. In a further example, the probe may be heated prior to frictioning by other means such as electric resistance (Joule) heating. In the latter case the probe may conveniently take the form of a thin blade or knife.

One advantage of the method according to the invention is that the depth of operation, and hence the depth of suitably heated or plasticised material is accurately controlled and known in advance.

Some examples of methods according to the invention will now be described and contrasted with comparative examples with reference to the accompanying drawings, in which:-

Figure 1 is an isometric view illustrating one comparative method;

Figures 2a and 2b are side elevations of two different rotating members;

Figure 3 is a plan illustrating the flow of plasticised material and surface marking with respect to the joint line;

Figure 4 is an isometric view illustrating a second comparative method;

Figures 5a, b & c are examples of blades used in reciprocating motion;

Figure 6 is an isometric view of a variation of the method of Figure 4 for making a scarf joint;

Figures 7a, b & c are an isometric view, end view and plan respectively of a third comparative example;

Figures 8a, b, and c show various examples of probe shape for use with the method of Figure 7;

Figure 9 illustrates an example of the invention in which the probe is inserted and entrapped in the parent material; and,

Figure 10 shows an example of a probe adapted as insert bush or stud according to the method of Figure 9.

Figures 1 to 8 illustrate comparative examples which are described and claimed in our co-pending European Patent Application No. 92923936.6.

In the example shown in Figure 1, a pair of aluminium alloy plates 1A, 1B are butted together about a joint line 2. A non-consumable probe 3 of steel having a narrow central, cylindrical portion 4 positioned between upper and lower sections 5, 6 is brought to the edge of the joint line 2 between the plates 1A, 1B. The probe 3 is rotated by a motor 7 while the probe is traversed in a direction 8 and while the plates are held against lateral movement away from the probe 3. The rotating probe 3 produces a local region of highly plasticised material around the steel "pencil" portion 4 while top and

bottom constraint is provided by the sections 5,6.

It should be noted that the constraining faces of the sections 5,6 are close fitting onto the sheets 1A,1B to be joined to avoid loss of material from the plasticised zone. The rotating member 3 or the bobbin can be manufactured in one piece as shown in Figure 2a, with a preset gap (typically 3.3mm) between the faces 5A,6A.

Alternatively, the bobbin may be demountable and the two parts 5,6' secured, for example, by a cotter pin 9, as shown in Figure 2b. For this it is convenient to drill a hole corresponding to the pin diameter in the butting sheets to be joined and the two parts 5,6' of the bobbin brought together firmly onto the sheets before securing. Furthermore, the gap may be made adjustable over a short distance by a suitable cam lever or eccentric (not shown) to allow for variation in the thickness of the sheets to be joined from nominal values. Yet again, the component parts of the bobbin may be suitably spring-loaded so that a tight fit is maintained in spite of small variation in the sheet thickness. In all cases to avoid pre-drilling a suitable hole in the butting sheets to be joined, a suitable run-on (and run-off) tab can be utilised. For example, a split piece of similar material to that being joined can be fastened around the pin of the rotating member and pressed against the starting edge of the sheets to be joined, so that as plasticised material is formed there is minimum space for escape and a uniform zone is formed throughout the length of the seam to be joined.

The butting faces 5A,6A of the bobbin may be machined substantially square but preferably are provided with a slight chamfer on the outer edges (Figure 2a). In use, it can be observed whether the top and bottom faces are in good contact with the materials to be joined by the visibly polished zone corresponding in width to the diameter of the faces up to the chamfer. Alternatively, and particularly for the spring loaded version, the face can be slightly domed with a radius of the order of 0.1m or greater, such that a contact zone corresponding to the applied spring load is developed of sufficient width. Preferably the width of this contact zone should be at least 50% greater than the diameter of the pin generating plasticised material.

With suitable bobbins as described the rotating member can be driven via a spline such that it floats according to the materials being joined. With pre-machined components in a suitable jig then a floating head is not necessary and a preset bobbin can be used.

In one case, a 6mm diameter pin was rotated at 1500rpm (peripheral speed of approximately 0.47m/sec) and traversed along the joint line at 370mm per minute.

As illustrated in Figure 3, the plasticised material is swept around the rotating probe 4 such that voids, if any, tend to form on the side where the rotating surface is moving in the same direction as the travel along the joint (advancing edge). It appears there is no difficulty in obtaining complete consolidation with the plasticised material filling the joint zone in other regions, particularly on the side where the rotating surface is against the direction of travel of the bobbin through the material (retreating edge).

Figure 4 shows a further comparative method by which the heating is obtained from a reciprocating blade 11 about which plasticised material is formed, and which is passed along the joint line 2. As previously the mechanical motion generates frictional heat in the plasticised material which, with traverse, flows from the leading to the trailing edges of the blade 11 and on cooling completes the butt joint between the materials to be joined. The blade 11 can be reciprocated from one side only or between two synchronized heads on either side of the materials. For making the butt joint, the sheets 1A,1B are placed in contact but generally without an abutment load prior to traversing the blade 11 along the joint line. If necessary guard plates can be mounted above and below the materials to be joined to prevent excessive displacement of plasticised material out of the joint zone. Also for some materials a degree of pre-heating the blade 11, e.g., by passing an electric current down the length of the blade can add to the heating due to rapid mechanical shear in the plasticised zone.

Although a simple thin rectangular blade 11 can in principle be used, it is preferable for the reciprocating blade to be shaped in cross section and in particular to have a relatively narrow wedge shaped trailing edge. A double wedge profile is shown in Figure 5a where the overall length in the direction of travel is preferably between 5 and 15 times the width. The width should be as small as convenient, such as around 1mm, and the blade made of material which is sufficiently strong at the melting point temperatures of the thermoplastic, i.e., at temperatures between 250 and 300°C to withstand the mechanical forces and in particular to not buckle. For example, tool steel or other hard steel can be ground into the shape desired and the surface polished to give a fine finish. Where desirable, the blade can pass through guard plates to prevent excessive plasticised material being taken out of the joint zone, and these guard plates may also be made of tool steel and lined with a low frictional resistance material such as PTFE. The double wedge shape is particularly useful for moving in either direction along the common joint line.

A single ended wedge is shown in Figure 5b where preferably the overall length is between 3

and 10 times the width and the leading edge is rounded. This shape is used with the rounded end in the direction of travel along a straight joint line and can also be used for joining along a curved line of relatively large radius. A further arrangement for curved joints is shown in Figure 5c, where the trailing edge is curved in section to correspond approximately with the curvature of the joint line.

For the reciprocating blades the displacement is preferably equal to or less than half the overall thickness of the material being joined, i.e., ± 3 mm or less for 6mm sheet and so forth. Greater strokes lead to excessive loss of material from the joint and consequent voids or porosity. It is noted that the plasticised material tends to cling to the blade and is pulled and pushed with reciprocating motion in the through thickness direction. Operating conditions are chosen such that the build up of plasticised material on the blade is avoided or minimised.

The frequency of reciprocating motion depends partly on the amplitude, and partly on the material being joined. Preferably the maximum (sinusoidal) velocity in the mid stroke position is in the region of 0.5m/sec to 5 m/sec. For materials such as polyethylene and PVC the preferred velocities are in the range of 0.75 metre per second to 4.5 metres per second. The higher velocities lead to greater heating and in the limit to degradation of the thermoplastic material.

To assist in initiation of the seam the reciprocating blade 11 can be pre-heated prior to the frictional operation. Any convenient method can be used i.e., Joule heating of the blade, or heating by hot gases, or maintaining the blade in a pre-heated sheath prior to use. Where advantageous the blade may also be electrically heated in use as well as developing thermal energy through mechanical work.

In one example, the blade stroke was approximately ± 3 mm at around 47Hz giving a maximum sinusoidal mid stroke speed of 0.88 metre per second. The butt joint is completed at a rate of 30mm per minute giving an overall joint completion rate (depth and length per unit time) of 3mm² per second.

An alternative approach to increase the effective joint strength is shown in Figure 6 where with the same reciprocating blade 11 a scarf joint is made between two abutting sheets 13,14 having sloped edges 13A,14A defining a joint region 15. This arrangement also allows the two sheets 13,14 to be held in position via rollers 16,17 and any tendency to pull apart restrained.

It should be noted that the end load in the direction of travel of the reciprocating blade 11 under suitable joining conditions is relatively low and only a simple traverse mechanism is required to maintain uniform motion.

Alternatively and particularly for thin sheet below 10mm, it is possible to use a hand tool similar to a conventional jig saw for achieving the joint between butting or overlapping plastic materials.

For curved joint lines a relatively thin blade of small longitudinal dimension such as 1mm x 4mm of the general shape shown in Figure 5c is desirable. Such hand tools can also be fitted with caterpillar type crawler tracks to maintain a uniform forward velocity. The tracks may be made with rubber impregnated track faces or partially evacuated to improve traction and adherence to the surface of the plastic material.

In the comparative example of Figure 7 the non-consumable member has a slightly tapered cylindrical probe 18 at its leading end, which is pressed against and becomes inserted between the plates 1A,1B, but does not extend completely through the thickness of the materials being joined as shown in Figure 7b. The surface appearance of the plates after the butt welding operation is shown in Figure 7c for the upper surface.

The shape of the probe is important. A simple conical point (Figure 8a) enables the probe to enter the plates butted together relatively easily but results in a narrowing of the plasticised region near the apex of the probe. Alternatively, a truncated cone, such as shown in Figure 8b, requires preferably a pre-drilled depression in the butting sheets to be joined. Preferably the probe is of a slightly tapered cylindrical form with a blunt nose, as shown in Figure 8c. This enables the probe to be pressed against the sheets so that it becomes inserted forming a plasticised zone around the probe which travels along the joint seam as previously described.

For a joint between aluminium alloy plates 6mm thick made by the method illustrated in Figure 7, the probe may be rotated at 850rpm and traversed along the joint line at 240mm per minute. Higher rotational speeds, such as 1000rpm, enable greater travel rates to be used up to say 300mm per second, but increasing the travel rate excessively leads to the formation of pores along one side as was found with the parallel sided arrangement of Figure 1. Alternatively, the rotational speed can be reduced such as down to 300rpm with a corresponding reduction in travel rate. For a given travel speed there is a reasonable tolerance in rotational rates such as at 4mm per second (240mm per minute) for the aluminium silicon magnesium alloy (BS6082) satisfactory results are obtained for rotational speeds between 440 and 850rpm.

The contact face 22 (Figure 7b) of each single ended probe can be substantially square or preferably with a small chamfer to relieve the outer edge. The appropriate load or positioning of the rotating

probe is then given by the appearance of the plate surface which should show that the face is in contact from the wide but thin layer of disturbed material. Alternatively, the face of the rotating member can be slightly domed as for the face of the bobbin in Figure 2, such that at a given load the surface contact area expands to at least 50% greater than the diameter of the probe itself. Contact zones up to three times probe diameter have been found satisfactory. For thinner materials it is preferable to scale the probe such that, for example, it is reduced to 4 or 3mm. Unexpectedly the preferred rotational speed is also reduced together with the travel rate for a smaller diameter probe. For example with a 3.3mm diameter probe a rotational speed of 440rpm and 120mm per minute travel is satisfactory.

In all these cases the slight taper of the probe face 22 amounts to around 2°.

A similar technique for making a local joint or weld but without traversing the tool for generating frictional heating can be utilised for a probe applied to one-side of the material. Here, for example, the plasticised material formed is utilised to stitch together two components at discrete intervals along their common interface. In like manner a crack can be held together by local plasticised material at one or more regions along its length. In these examples the probe can be left in-situ surrounded by the plasticised material so formed. Preferably in this arrangement the probe can be in a collet with a suitable end face to help prevent excessive dispersal of the plasticised material displaced by the probe.

Figure 9 illustrates an example of the invention in which a probe 24 for forming a local plasticised zone in a single locality has re-entrant regions 25 such that on inserting the probe into the material the plasticised material flows into the re-entrant regions. On cooling the probe is entrapped by the material, apart from any metallurgical bond between the probe material and the surrounding plasticised material. The probe is supported by a shoulder 26 as in the arrangements of Figures 7 and 8 to provide further heating and to prevent excessive dispersal of the plasticised material being formed.

The above technique may also be utilised for inserting and entrapping probes of harder/stronger material into a softer/weaker material to act as fixtures for attaching other components to the weaker material. An example is shown in Figure 10 of such a probe 27 adapted as a stud or bush for insertion, which is stronger or more durable than the parent material.

These and other variations of the method according to the invention in which plasticised material is generated by frictional shear from a sepa-

rate component inserted into the parent material and which on cooling surrounds the component to restrain it in the material is within the scope of this invention.

In all these examples, the result of the welding operation is an extremely smooth finish on the surfaces of the plates which is a particular advantage of this process. This can be improved by providing Ferodo brake material on the facing surface of the non-consumable probe. Typically the rotational speed of the non-consumable will be between 300 and 600 rpm and the traverse rate of the work piece is in the range of 1 to 6mm/sec. Typically, the non-consumable will be made of an alloy steel.

Specimens have been produced and subjected to mechanical tensile and hammer bend tests as well as metallurgical evaluation which have demonstrated the practicability of the process.

The advantages of the process can be summarised as follows:

- Non-consumable technique
- Continuous - unlimited length
- No preparation
- Reasonable smooth finish
- Good mechanical properties
- Solid phase,
- Low distortion
- Limited axial load ie. no axial feed only light contact
- Key hole technique
- Portable equipment KAT driven
- Simple to use
- Low cost capital equipment
- Fast freeze 5G position

Claims

1. A method of operating on a workpiece, the method comprising offering a probe of material harder than the workpiece material to a continuous or substantially continuous surface of the workpiece, the probe depending from a containment member having a surface which faces the workpiece; causing relative cyclic movement between the probe and the workpiece while urging the probe and workpiece together whereby frictional heat is generated as the probe enters the workpiece so as to create a plasticised region in the workpiece material around the probe, the containment member substantially preventing dispersal of the plasticised material; stopping the relative cyclic movement; and allowing the plasticised material to solidify around the probe.
2. A method according to claim 1, wherein at least part of the probe which enters the work-

piece is shaped so as to key into the solidified material.

3. A method according to claim 2, wherein the probe tapers outwardly in a direction towards the workpiece. 5
4. A method according to claim 2 or claim 3, wherein the probe has a radially outwardly facing re-entrant feature. 10
5. A method according to any of the preceding claims, wherein the leading end of the probe includes a recess. 15
6. A method according to any of the preceding claims, wherein the probe has an elongate axis and undergoes cyclic movement in a direction generally parallel with its elongate axis. 20
7. A method according to claim 6, wherein the cyclic movement is a rotation.
8. A method according to any of the preceding claims, wherein a cross-section through the probe is substantially circular. 25

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Fig.1.

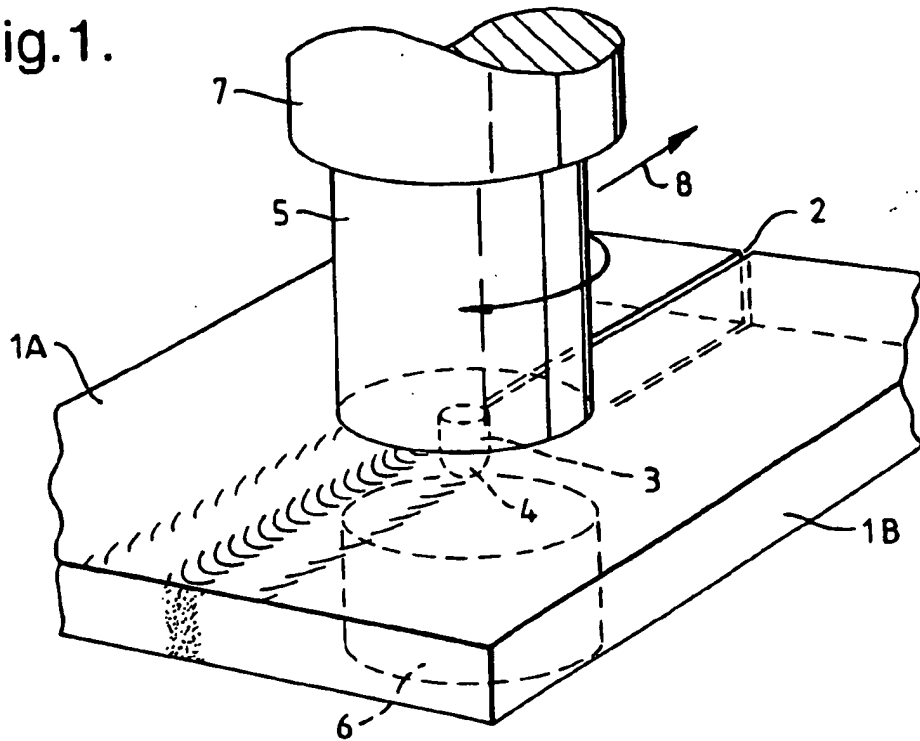


Fig.2A.

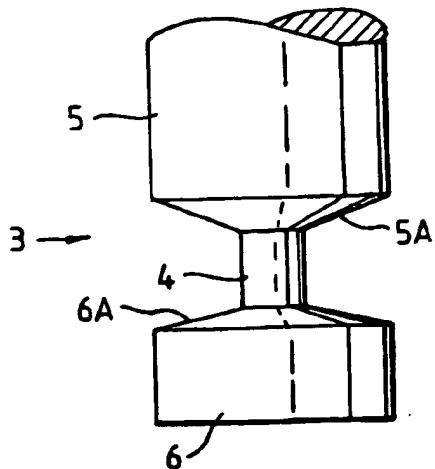


Fig.2B.

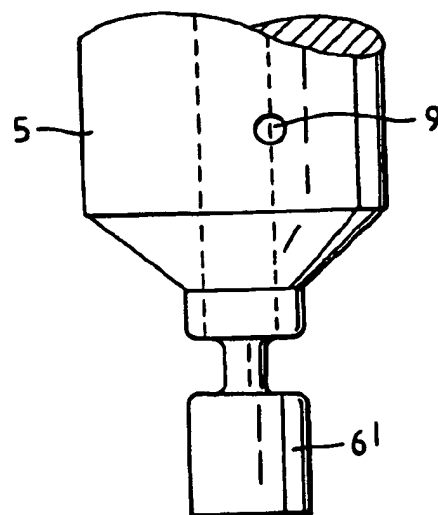


Fig.3.

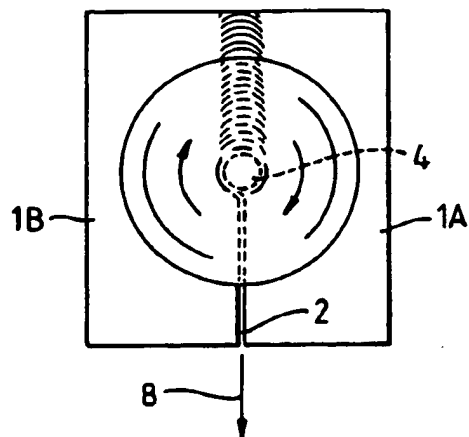


Fig.4.

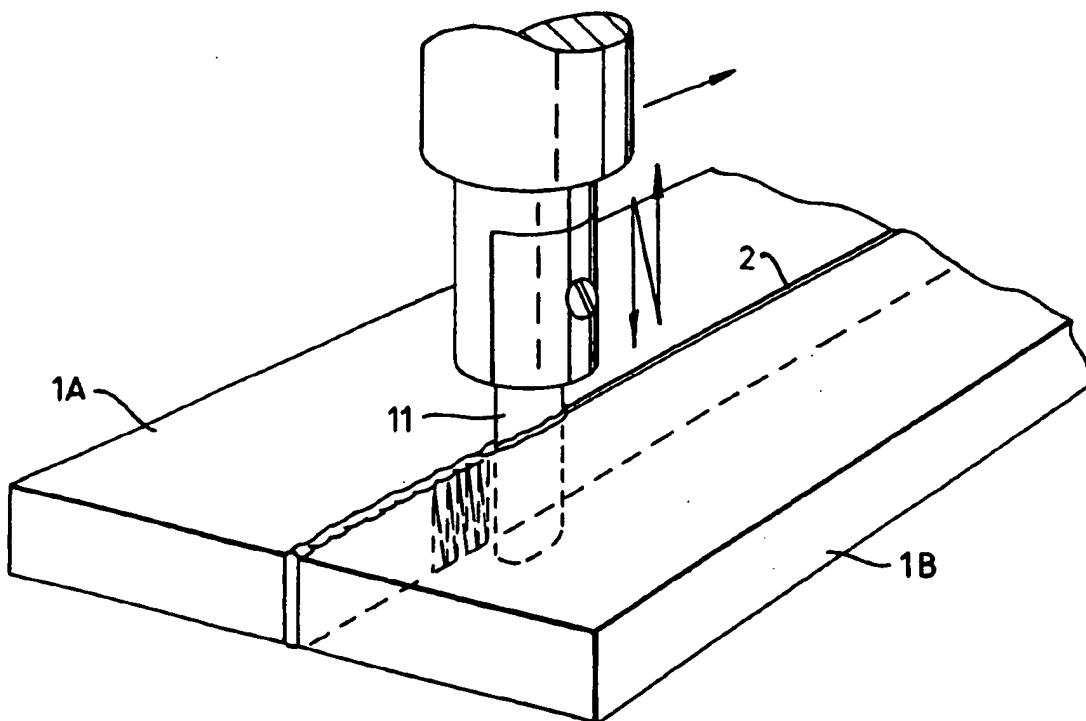


Fig.5A.



Fig.5B.



Fig.5C.



Fig.6.

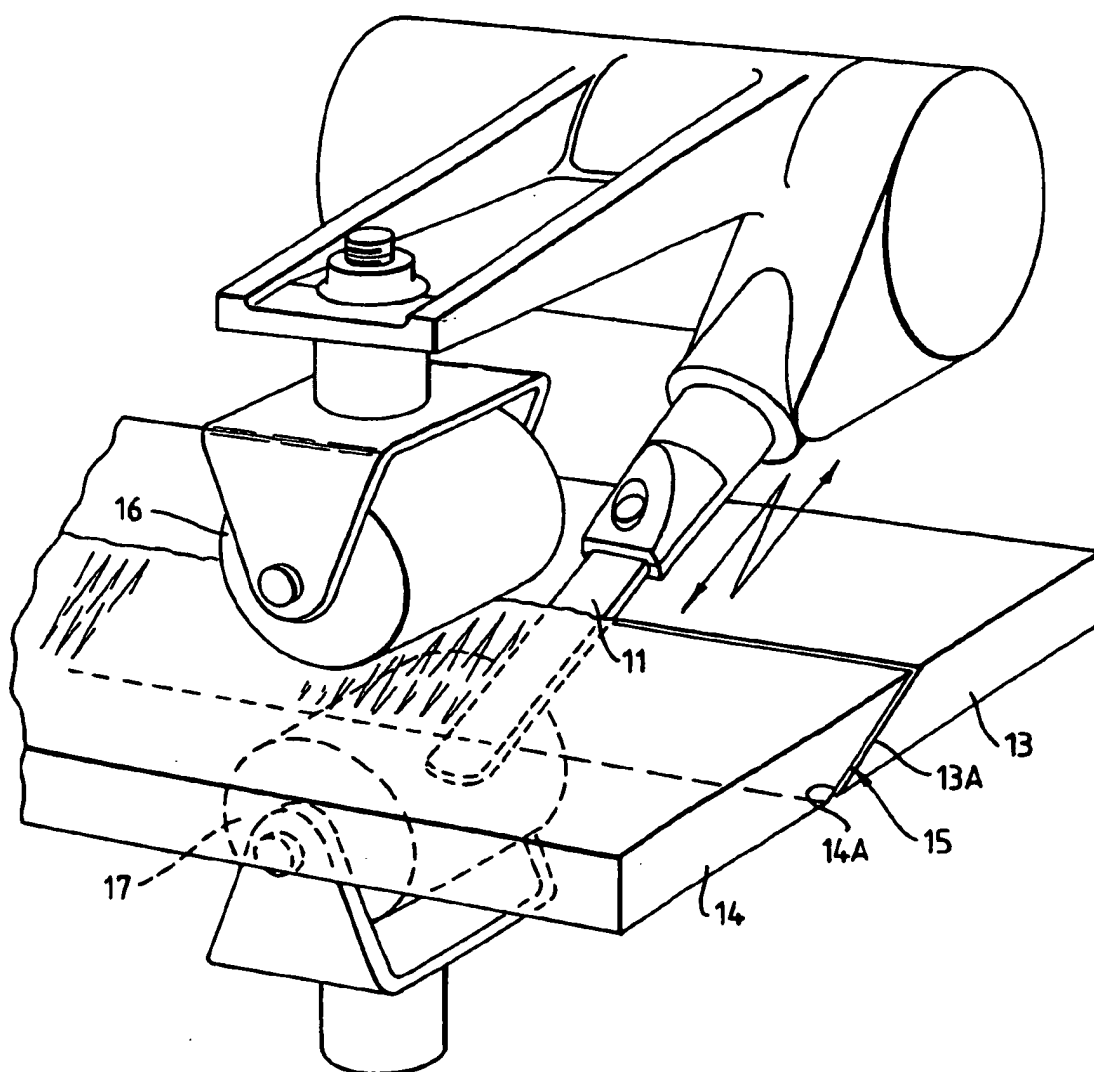


Fig.7A.

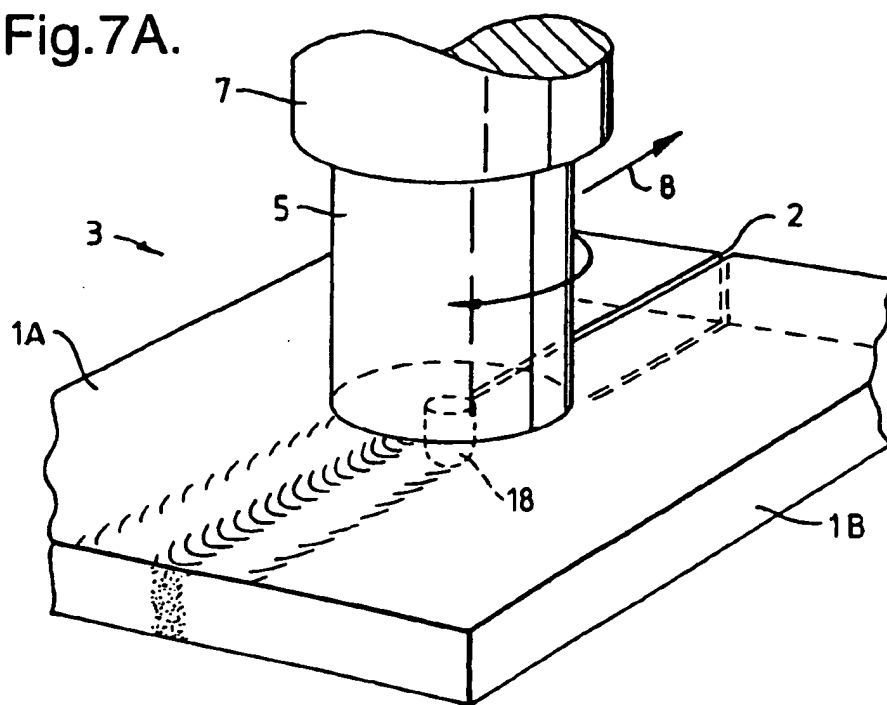


Fig.7B.

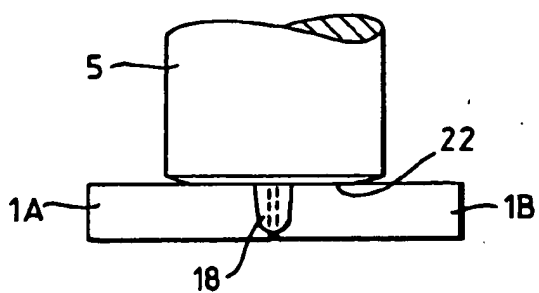


Fig.7C.

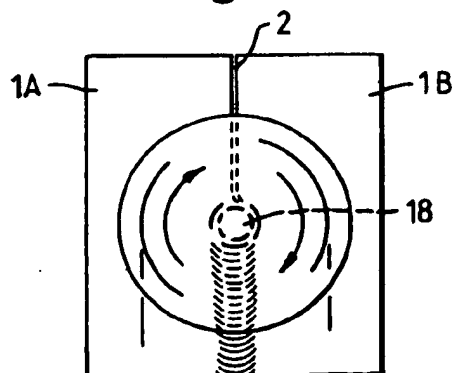


Fig.8A.

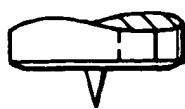


Fig.8B.



Fig.8C.

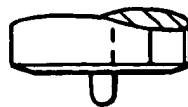


Fig.9.

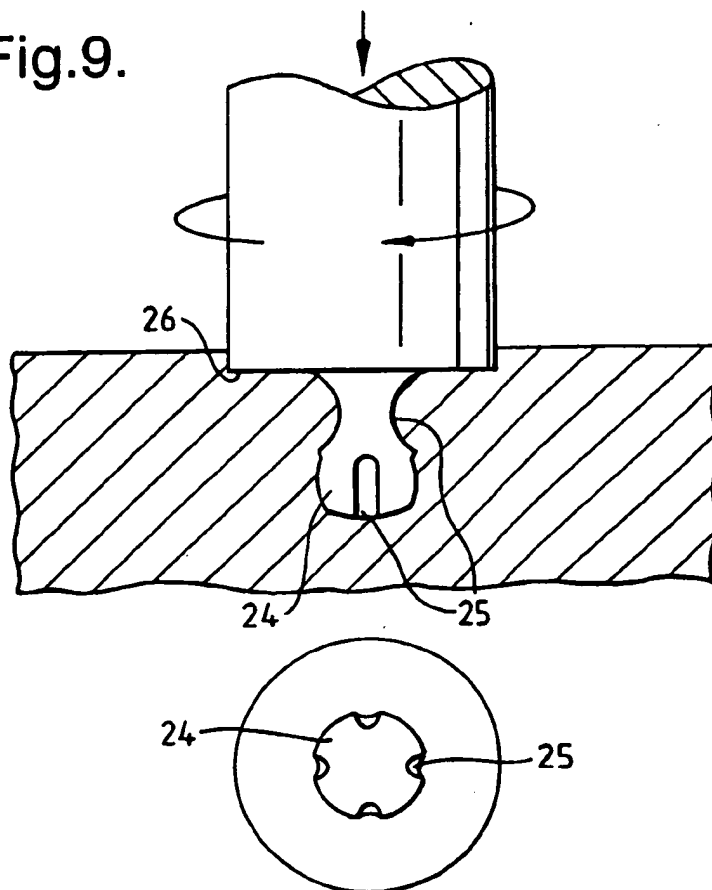
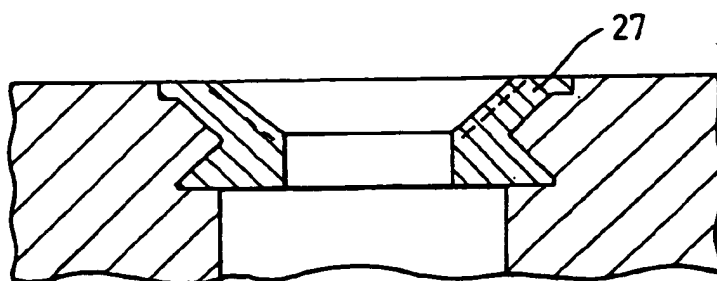


Fig.10.





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(71) Applicant: THE WELDING INSTITUTE
Abington Hall
Abington
Cambridge CB1 6AL (GB)

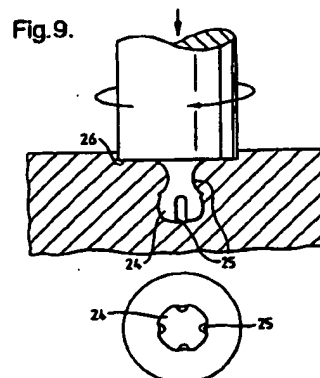
(72) Inventor: Thomas, Wayne Morris
6 Howe Road
Haverhill,
Suffolk CB9 9NT (GB)
Inventor: Murch, Michael George
6 Middle Street,
Triplow

Royston,
Herts, SG8 7RD (GB)
Inventor: Nicholas, Edward David
106 Abbotts Road,
Haverhill
Suffolk,
Cambridge, CB9 0DH (GB)
Inventor: Temple-Smith, Peter
The Haven,
60 Lode Road
Lode,
Cambridge, CB5 9ET (GB)
Inventor: Needham, James Christopher
5 Blacklands Close
Saffron Walden,
Essex (GB)
Inventor: Dawes, Christopher John
9 Queensway
Sawston,
Cambs, CB2 4DJ (GB)

(74) Representative: Skone James, Robert Edmund
GILL JENNINGS & EVERY
Broadgate House
7 Eldon Street
London EC2M 7LH (GB)

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EUROPEAN SEARCH REPORT

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.5)
A	DATABASE WPI Section Ch, Week 8829 Derwent Publications Ltd., London, GB; Class M21, AN 88-203819 & SU-A-1 362 593 (DNEPR PIPE ROLLING WKS) , 30 December 1987 * abstract *	1	B23K20/12 B29C65/06
A	US-A-4 144 110 (LUC JANE) 13 March 1979 ---	1	
A	DATABASE WPI Section Ch, Week 8927 Derwent Publications Ltd., London, GB; Class M23, AN 89-199319 & SU-A-1 433 522 (DNEPR METAL INST) , 30 October 1988 * abstract *	1	
A	PATENT ABSTRACTS OF JAPAN vol. 006 no. 253 (M-178) ,11 December 1982 & JP-A-57 149082 (KAWASAKI JUKOGYO KK) 14 September 1982, * abstract *	1	TECHNICAL FIELDS SEARCHED (Int.Cl.5) B23K B29C
A	PATENT ABSTRACTS OF JAPAN vol. 010 no. 388 (M-549) ,25 December 1986 & JP-A-61 176484 (ISHIKAWAJIMA HARIMA HEAVY IND CO LTD) 8 August 1986, * abstract *	1	
A	GB-A-572 789 (H. KLOPSTOCK) 24 October 1945 -----		
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 11 May 1995	Examiner De Smet, F
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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